

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020484**Date Inspected:** 07-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng /Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 002 located on BK004A6-033. Welder is identified as 053869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 007 located on BK004A6-033. Welder is identified as 040533. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 014 located on BK004A2-032. Welder is identified as 216366. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

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### In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 084 located on BK0011A6-001. Welder is identified as 053316. ZPMC Quality Control (QC) is identified as Xu Le Feng.. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08075.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK004CSD1-024-001, 002, 003, 004, 022, 023, 024, 027

BK009A2-001-026, 027, 028, 029, 030

BK009A1-001-001, 002, 003

BK004A6-033-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 092, 086, 092, 096, 102

BK004A8-033-090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102, 063, 070, 080, 078

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08078.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK008A2-002-016, 018

WSD1-FFSA6-4-23A

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08082.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK010A1-001-001

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08084.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

WSD1-FESA6-4-1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 27, 28, 29, 30

BK008A2-002-016, 018

### Magnetic Particle Inspection (MT)

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The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08075.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK004CSD1-024-001, 002, 003, 004, 022, 023, 024, 027

BK009A2-001-026, 027, 028, 029, 030

BK009A1-001-001, 002, 003

BK004A6-033-063, 070, 080, 078, 090, 088, 100, 098, 061, 065, 076, 092, 086, 092, 096, 102

BK004A8-033-090, 088, 100, 098, 061, 065, 076, 082, 086, 092, 096, 102, 063, 070, 080, 078

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08078.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK008A2-002-016, 018

WSD1-FFSA6-4-23A

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08082.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK010A1-001-001

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 08084.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

WSD1-FESA6-4-1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 27, 28, 29, 30

BK008A2-002-016, 018

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt, Scott
<b>Reviewed By:</b>	Clifford, William

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Quality Assurance Inspector
QA Reviewer

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